

Date: Tuesday, 27/01/2009 11:11:43 AM  
 User: Julie Dawson

## Process Sheet

|   |  |
|---|--|
| <b>Customer</b> : CU-DAR001 Dart Helicopters Services   | <b>Drawing Name</b> : PANEL                                |
| <b>Job Number</b> : 45276   |  |
| <b>Estimate Number</b> : 10769  |  |
| <b>P.O. Number</b> :  | <b>Part Number</b> : D33301                                |
| <b>This Issue</b> : 27/01/2009 <b>S.O. No.</b> :  | <b>Drawing Number</b> : D3330 REV D                        |
| <b>Prsht Rev.</b> : NC  | <b>Project Number</b> : N/A                                |
| <b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB   | <b>Drawing Revision</b> : D                                |
| <b>Previous Run</b> : 44238   | <b>Material</b> :  |
| <b>Written By</b> :   | <b>Due Date</b> : 05/02/2009 <b>Qty:</b> 4 <b>Um:</b> Each |
| <b>Checked &amp; Approved By</b> : <u>JUD 09.01.27</u>  |  |
| <b>Comment</b> : Est: A 05.01.13 New issue KJ/JLM<br>Est Rev:B Now on Waterjet 06-09-25 JLM<br>est C 07.05.14 rev c dwg ec<br>EST D 07.12.12 revD dwg EC verified by:DD |  |

## Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

|     |           |                      |
|-----|-----------|----------------------|
| 1.0 | M1010S125 | 1010-1025 sheet .125 |
|-----|-----------|----------------------|



**Comment:** Qty.: 1.1445 sf(s)/Unit Total : 4.5780 sf(s)  
 1010-1025 sheet .125  
 Batch: 109947 IB 9-2-3

|     |           |                |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D3330  
 Dwg Rev: B IB 9-2-3  
 Prog Rev: B

2-Deburr if necessary IB 9-2-3

(4)

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

|     |     |              |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



**Comment:** SECOND CHECK

509/02/03 (20)

|     |          |          |
|-----|----------|----------|
| 5.0 | BRAKE NC | NC BRAKE |
|-----|----------|----------|



**Comment:** NC BRAKE  
 Form as per Dwg D3330

SB 09/02/24 (9)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Tuesday, 27/01/2009 11:11:43 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL

Job Number: 45276

Part Number: D33301

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 09/02/24 (X4)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

WA

U 09.02.25

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/25 J

Job Completion



U 09.02.25

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

|                              |               |                                  |
|------------------------------|---------------|----------------------------------|
| <b>DART AEROSPACE LTD</b>    |               | <b>Work Order:</b> <u>415276</u> |
| <b>Description:</b> Panel    |               | <b>Part Number:</b> D3330-1      |
| <b>Inspection Dwg:</b> D3330 | <b>Rev:</b> C | <b>Page 1 of 1</b>               |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

| Drawing Dimension | Tolerance     | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø0.327            | +0.006/-0.001 | .329             | x      |        |                      |          |
| 16.66             | +/-0.030      | 16.66            | x      |        |                      |          |
| 1.69              | +/-0.030      | 1.692            | x      |        |                      |          |
| 4.646             | +/-0.010      | 4.639            | x      |        |                      |          |
| 0.750             | +/-0.010      | .757             | x      |        |                      |          |
| 6.77              | +/-0.030      | 6.762            | x      |        |                      |          |
| 10.41             | +/-0.030      | 10.41            | x      |        |                      |          |
| 6.45              | +/-0.030      | 6.452            | x      |        |                      |          |
| 6.000             | +/-0.010      | 5.997            | x      |        |                      |          |
| 2.000 Pitch       | +/-0.010      | 1.996            | x      |        |                      |          |
| 2.323             | +/-0.010      | 2.319            | x      |        |                      |          |
| 0.80              | +/-0.030      | .797             | x      |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |

|                               |                              |                                |
|-------------------------------|------------------------------|--------------------------------|
| <b>Measured by:</b> <u>VB</u> | <b>Audited by:</b> <u>S</u>  | <b>Prototype Approval:</b> N/A |
| <b>Date:</b> <u>9-2-3</u>     | <b>Date:</b> <u>02/02/23</u> | <b>Date:</b> N/A               |

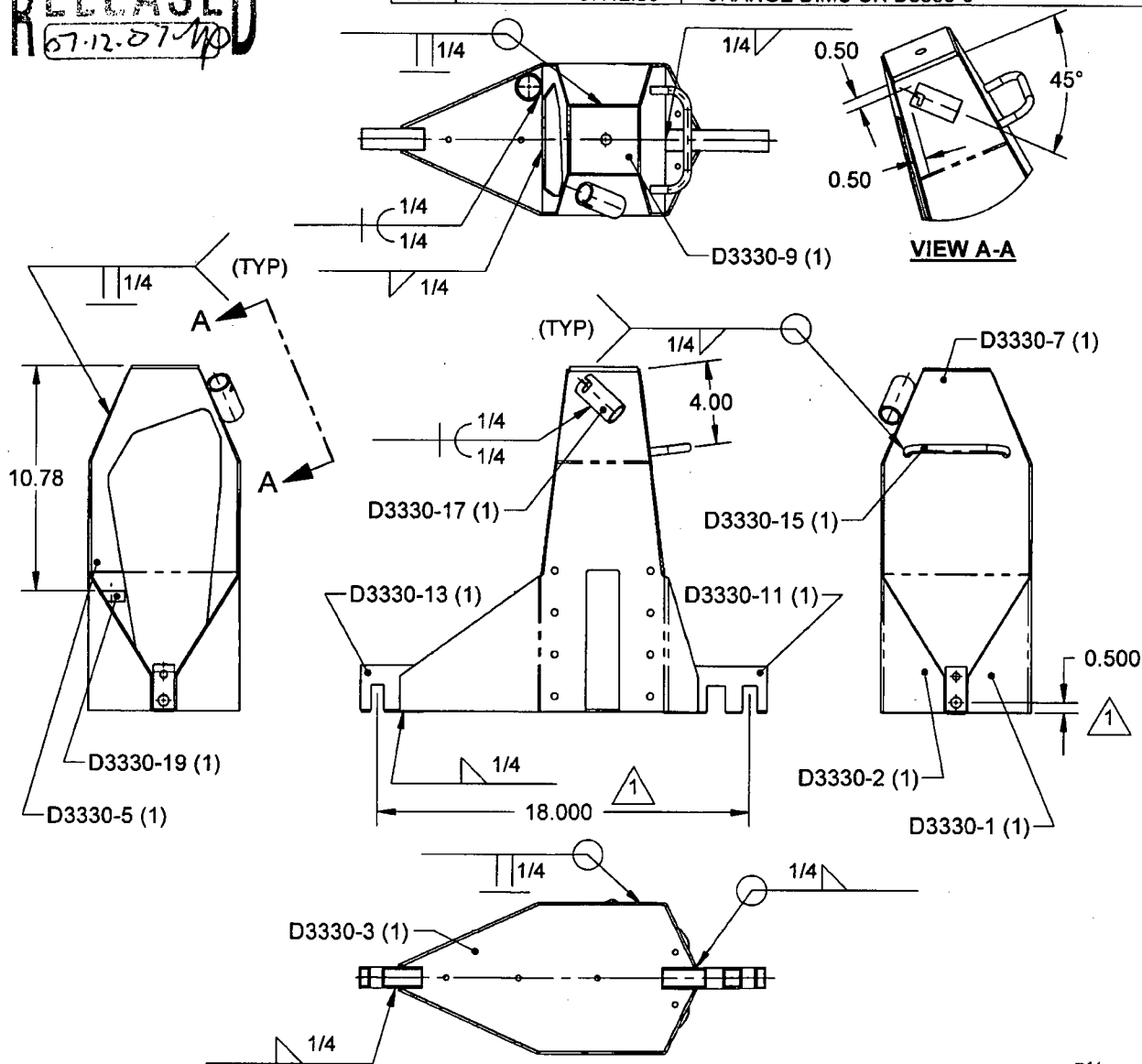
  

| Rev | Date     | Change          | Revised by      | Approved  |
|-----|----------|-----------------|-----------------|-----------|
| A   | 06.10.27 | New Issue       | KJ/JLM          |           |
| B   | 07.05.16 | Dwg Rev updated | KJ/EC <u>28</u> | <u>CE</u> |



| DESIGN<br><i>BS</i>     | DRAWN BY<br><i>DC</i>          | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
|-------------------------|--------------------------------|--|------------------------|
| CHECKED<br><i>BS</i>    | APPROVED<br><i>W</i>           | DRAWING NO.<br><b>D3330</b>                              | REV. D<br>SHEET 1 OF 9 |
| DATE<br><b>07.12.06</b> | TITLE<br><b>FRAME WELDMENT</b> |  | SCALE<br>1:8           |
| REV                     | DATE                           | DESCRIPTION  |                        |
| A                       | 04.12.16                       | NEW ISSUE  |                        |
| B                       | 05.02.26                       | RE-DESIGN  |                        |
| C                       | 07.03.20                       | ADD 0.100 DIM; RAISED BEND OF -1/2 BY 0.125              |                        |
| D                       | 07.12.06                       | CHANGE DIMS ON D3330-9                                   |                        |

RELEASED  
07.12.07



### D3330-041 FRAME WELDMENT

#### NOTES:

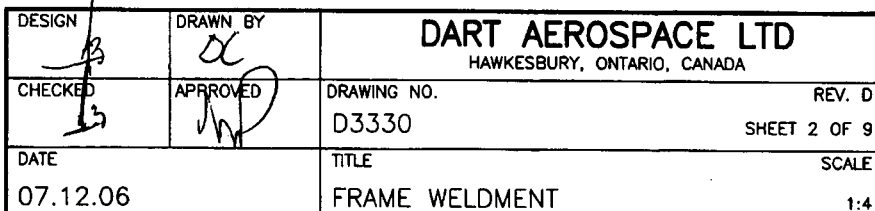
- 1) POSITION PARTS AS PER JIG D3330-041T1
- 2) WELD PER QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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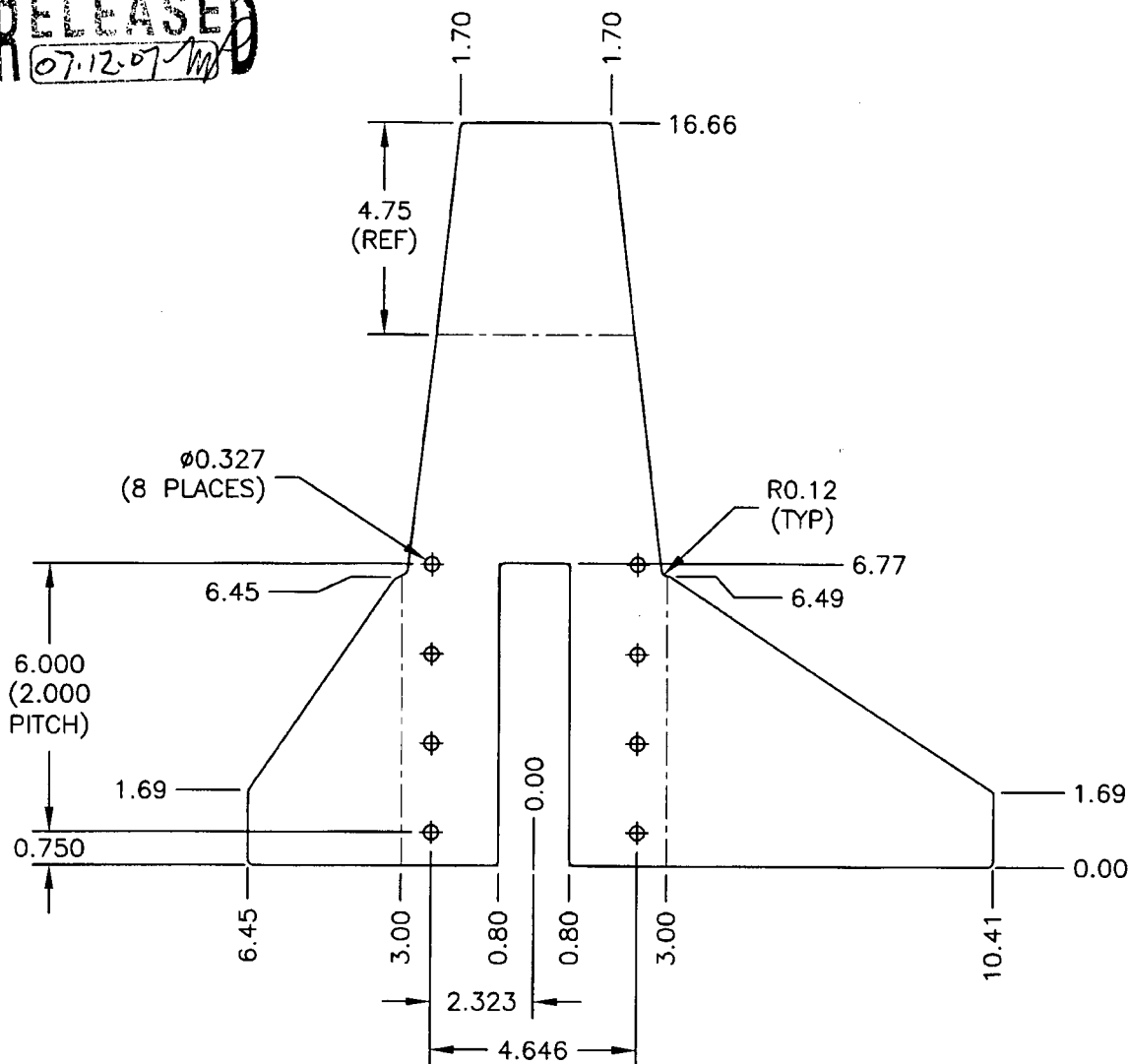
45276

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07.12.07



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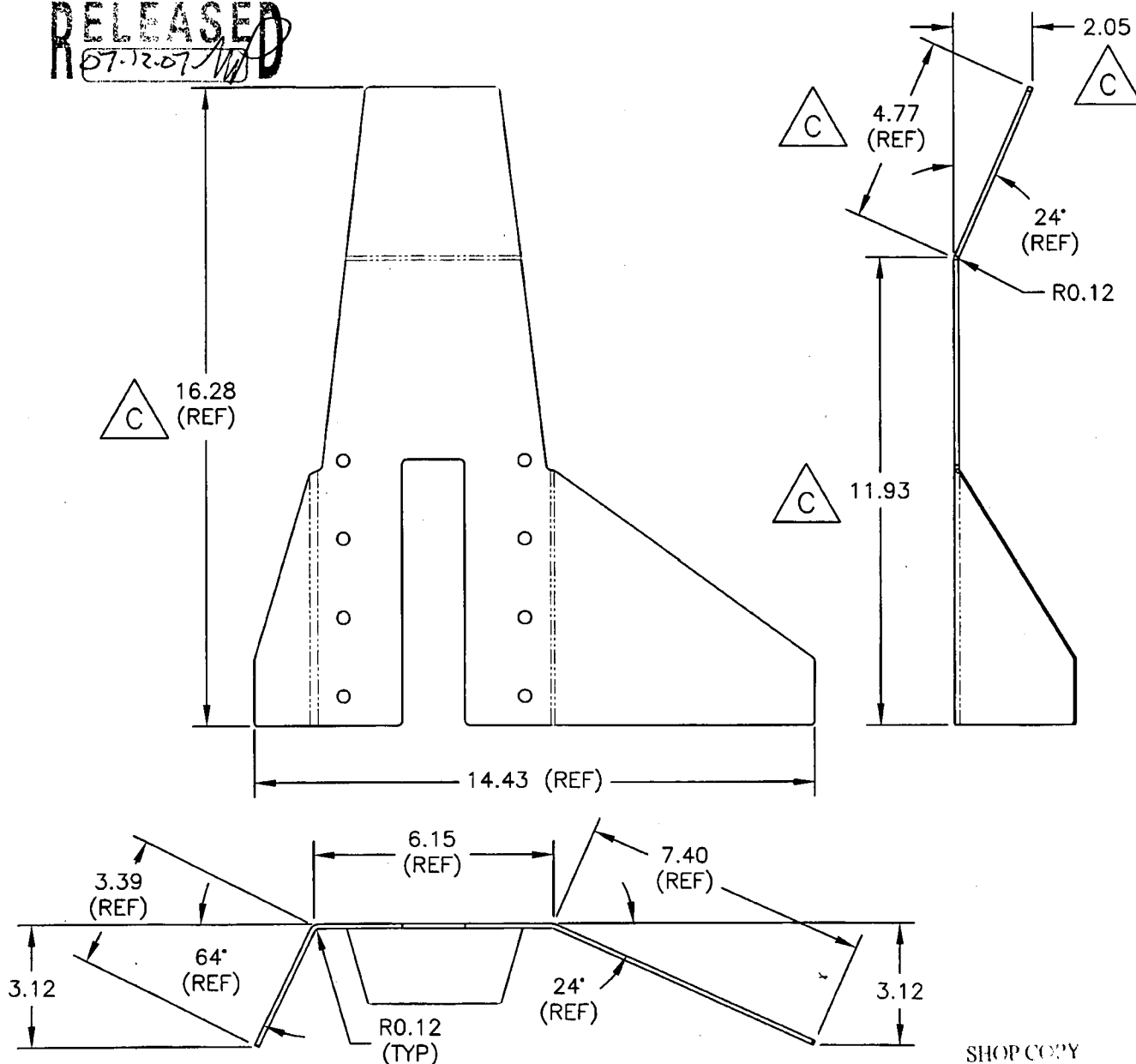
1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, SUBMIT TO ALL  
38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)  
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
3) ALL DIMENSIONS ARE INCHES  
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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|                      |                       |   |                        |
|----------------------|-----------------------|---|------------------------|
| DESIGN<br><i>JB</i>  | DRAWN BY<br><i>SC</i> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>JB</i> | APPROVED<br><i>MP</i> | DRAWING NO.<br>D3330                              | REV. D<br>SHEET 3 OF 9 |
| DATE<br>07.12.06     |                       | TITLE<br>FRAME WELDMENT                           | SCALE<br>1:4           |

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07.12.07



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